

Work Order ID 124554

124554

Page 1

Monday, September 15, 2014 11:05:04 AM

Item ID: D4494-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Block Assembly, LH
 Start Date: 9/15/2014 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 9/19/2014 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 14-09-15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4494	D								

100

100

Bandsaw
Jeaspa Bandsaw

Memo
CUT BLANK 6.6" LONG

0.00

0.00

110

110

Purchasing
Purchasing

Memo
ISSUE P/O: 25345
TO ARCHUR PRESISION(GLOBUS)
C OF C IS REQUIRED

0.00

0.00

CL 14/09/15 x2

120

120

QC
Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

(2)

DAS
38
9-89

DEC 01 2014

7 read + inspect
attached cufc + FAI 400/0

CL 14/12/01 x2

Work Order ID 124554***124554***

Page 2

Monday, September 15, 2014 11:05:05 AM

Item ID: D4494-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Block Assembly, LH

Start Date: 9/15/2014 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/19/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

14-12-01

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

DAS
38
9-89

DEC 01 2014

141

Spray Painting per QSI005 4.2

0.00

141

SprayPaint

Memo

0.00

Spray Painting

PRIME TEMPO GREY

130573

DAS
41
9-89

Dec 4, 2014

Work Order ID 124554

Monday, September 15, 2014 11:05:05 AM

124554

Page 3

Item ID: D4494-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Block Assembly, LH

Start Date: 9/15/2014 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/19/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

142

QC14- Inspect Spray Paint

0.00

142

QC

Memo

0.00

Quality Control

DEC 05 2014

150

0.00

150

Small Fab

Memo

0.00

Small Fab

install nutplates as per dwg

24 14/12/08 DAS 36 9-89

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

DAS 38 9-89

DEC 08 2014

Work Order ID 124554

Monday, September 15, 2014 11:05:05 AM

124554

Page 4

Item ID: D4494-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Block Assembly, LH
Start Date: 9/15/2014 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 9/19/2014 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>S1230</u>	0.00							
200									
Packaging	Memo	0.00				(2x)	DAS 46		DEC 08 2014
Packaging							9-89		
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

14/12/9 J

H4-12-09

Picklist Print

Monday, September 15, 2014 11:05:02 AM

Page 1

Work Order ID: 124554

124554

Parent Item: D4494-041

D4494-041

Parent Item Name: Upper Block Assembly, LH

Start Date: 9/15/2014

Required Date: 9/19/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-12-05 JLM VERIFIED BY:DD IPP
REV:B AS PER REV D JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20426AD3-4		Purchased		No		150	Each	4,996.000	4	8			DAS
--------------	--	-----------	--	----	--	-----	------	-----------	---	---	--	--	-----

MS20426AD3-4

RIVET

**

14/12/05

36
9-89

Location

Loc Qty

Loc Code

ST315

4996

125578

2530

m127432

2466

8

M6061T6B1.000X04.00

Purchased

No

100

f

82.2490

0.55

2

0

M6061T6B1.000X04.000

6061-T6 Bar 1.00 x 4.00

**

N/A mat supplied
by archer.

Location

Loc Qty

Loc Code

MAT003

82.249

124681

14.1

M126160

10

M127797

10.149

M129167

48

D4494-1P

Purchased

No

110

Each

0.0000

1

2

D4494-1P

Upper Block Lower Door, LH

**

CL14/12/01

Picklist Print

Monday, September 15, 2014 11:05:03 AM

Page 2

Work Order ID: 124554

124554

Parent Item: D4494-041

D4494-041

Parent Item Name: Upper Block Assembly, LH

Start Date: 9/15/2014

Required Date: 9/19/2014

Start Qty: 2.00

Required Qty: 2.00

MS21059L08

Purchased

No

150

Each

597.0000

2

4

MS21059L 08

Nut

14/12/05

DAS
36
9-89

Location

Loc Qty

Loc Code

ST304

225

m129934

225

ST508

372

123185

1

125654

367

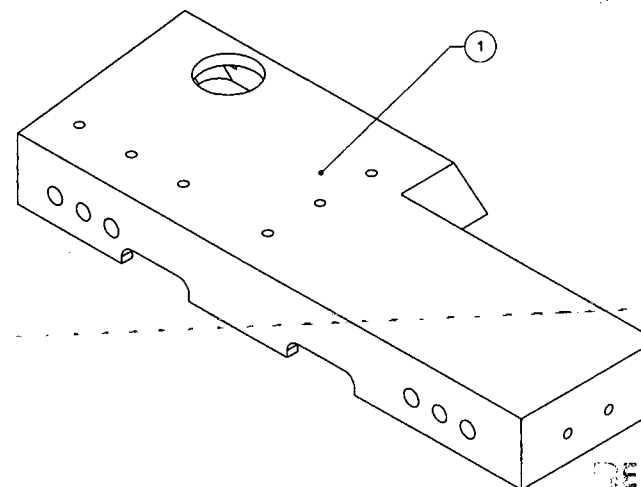
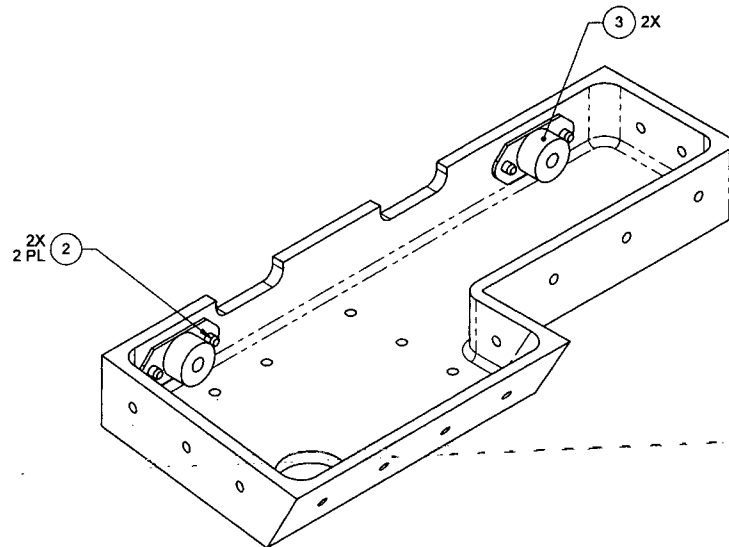
m124291

4

4

11

ITEM	QTY	P/N	DESCRIPTION
	-041		
	X	D4494-041	UPPER BLOCK ASSEMBLY (LH)
1	1	D4494-1	UPPER BLOCK LOWER DOOR (LH)
2	4	MS20426AD3-4	RIVET, CSK
3	2	MS21059L08	NUTPLATE

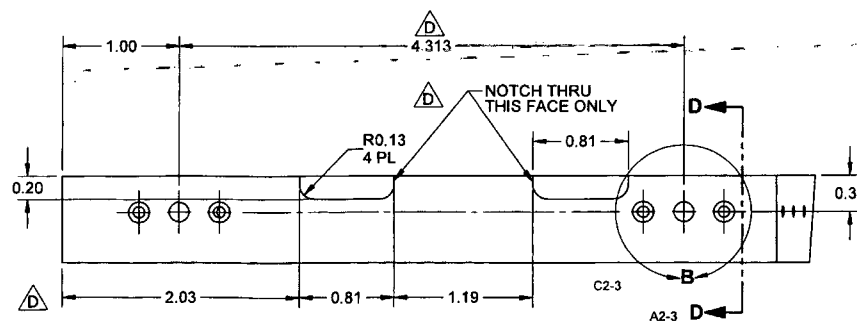
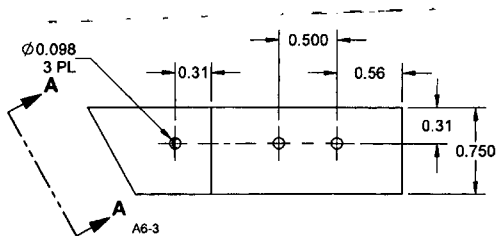
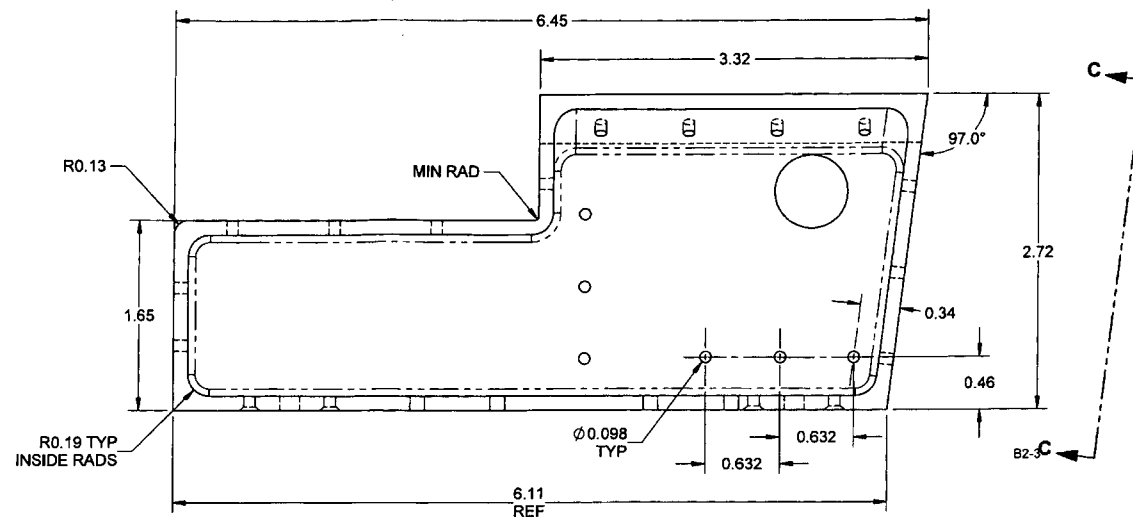


D4494-041 UPPER BLOCK ASSEMBLY (LH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.30 lbs

REV.	DESCRIPTION	BY	DATE
D	B4-2, 4.313 DIM WAS 4.000. NOTCHES ADDED. B5-5 4.313 DIM WAS 4.000. NOTCHES ADDED. REASON: LATCH MECHANISM RELOCATED AT NEXT ASSY. MODIFICATIONS DONE TO CLEAR NUTPLATES.	AJS	12.12.12
C	ADDED -042 & -2 (RH CONFIGURATION)	AJS	12.10.23
B	COMPLETE REDESIGN SEE REV. A FOR DETAILS. PRIMER NOTE ADDED.	AJS	12.09.13
A	NEW ISSUE	AJS	12.03.02
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	g/h	D4494	SHEET 1 OF 6
APPROVED	h/p	TITLE	SCALE
DE APPR.	h/p	UPPER BLOCK ASSEMBLY	NTS
DATE	12.12.12	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.28 lbs
- 8) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL)

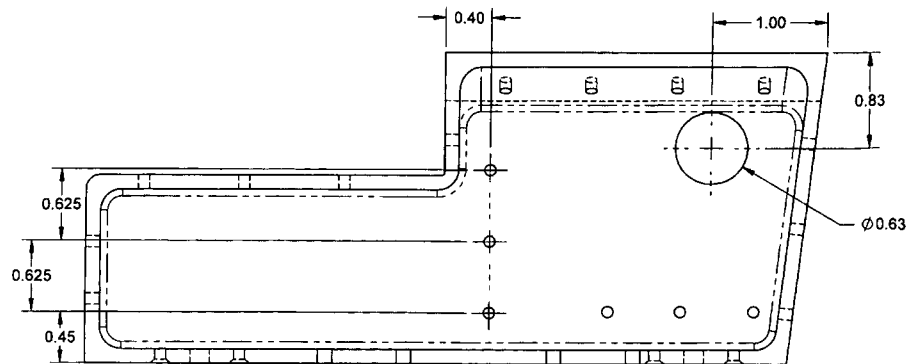
D4494-1 UPPER BLOCK LOWER DOOR (LH)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED	A.P.	DRAWING NO. D4494
MFG. APPR.	8/1	REV. D
APPROVED	1/10	SHEET 2 OF 6
DE APPR.	1/10	TITLE SCALE
DATE	12.12.12	UPPER BLOCK ASSEMBLY NTS

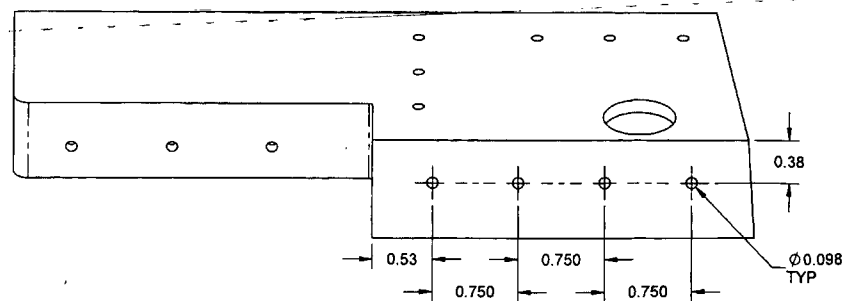
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RELEASED
2013-02-14

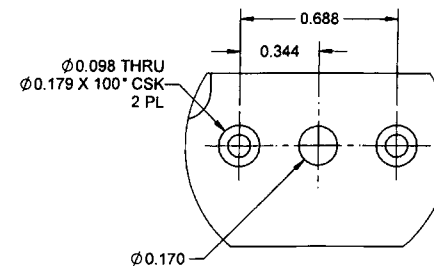
24



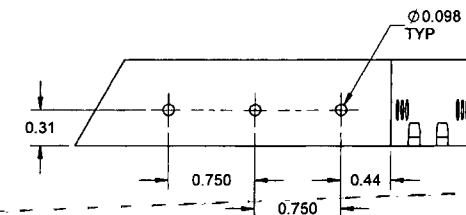
SUPPLEMENTAL VIEW



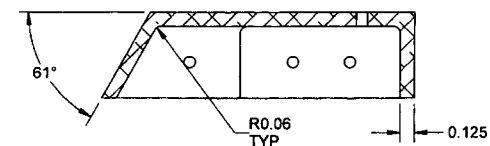
VIEW A-A B8-2



DETAIL B B3-2
NUPLATE HOLE DETAIL 2 PL
(SCALE 2X)



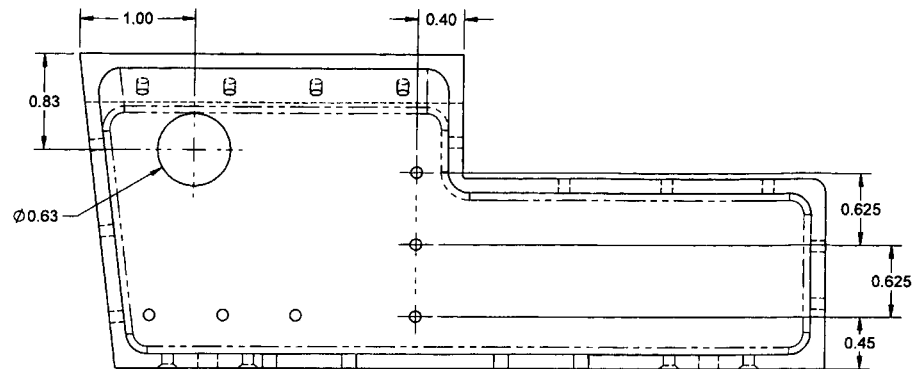
VIEW C-C C2-2



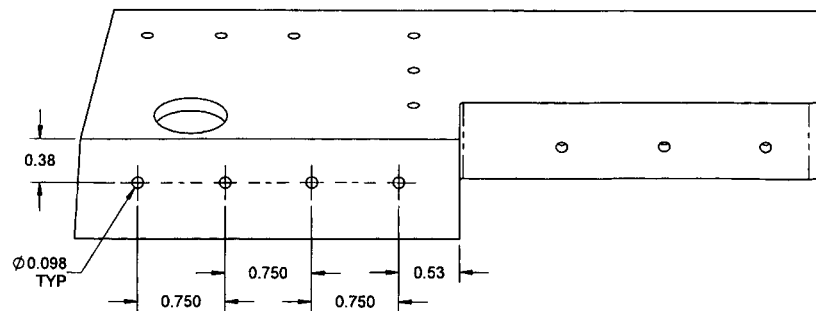
SECTION D-D B3-2

RELEASED
2013-02-14

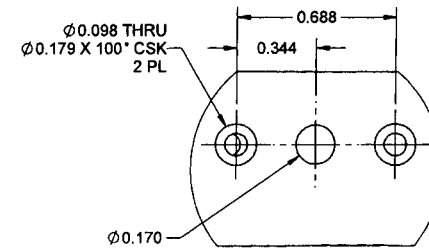
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AD</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AD</i>	D4494	SHEET 3 OF 6
APPROVED	<i>AD</i>	TITLE	SCALE
DE APPR.	<i>AD</i>	UPPER BLOCK ASSEMBLY	NTS
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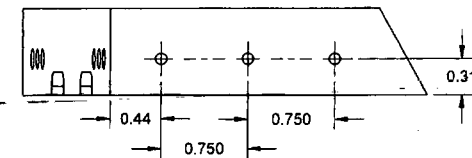
SUPPLEMENTAL VIEW



VIEW H-H B2-5

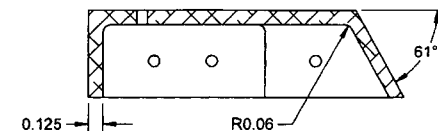


**DETAIL G B4-5
(SCALE 2X)**



VIEW F-F C7-5

RELEASED
2013-02-14



SECTION E-E B6-5

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	2/1	D4494	SHEET 6 OF 6
APPROVED	1/2	TITLE	SCALE
DE APPR.	1/2	UPPER BLOCK ASSEMBLY	NTS
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2 9/12



Supplier Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Friday, September 12, 2014

Raised Date 9/12/2014	Status Open	Owner Gregoire, Michael	Number NCR14-4207
Target Date 9/26/2014	Standard	Severity MAJOR	
Process Employee finding		Audit	
Raised By Person Downing, Eric M	Raised Against (Department or Supplier) Archer Precision Inc.	Fault Category Supplier	
Details found at alodine inspection (not QC 6 incoming inspection) that D4476-042 B123279 & D4473-042 B123280 machined on PO25345 @ Archer Precision were machined incorrectly. the parts are machined as -041 (LH) and not -042 (RH)			
Keywords		Product D4476-042 & D4473-042	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Target Date 9/26/2014	Owner Gregoire, Michael	Closed Date	Closed By
Details			

Number	Owner	Target Date	Completed Date
Details			
1	Gregoire, Michael	9/19/2014	
Contact Supplier and obtain corrective action and root cause for this issue			
2	Lacelle, Linda	9/19/2014	
create work orders to receive the parts in as -041 (LH)			
3	Downing, Eric M	9/26/2014	
retrain inspectors to remove all non necessary drawings and to be more attentive to the parts that are being received in at inspection record on job training logs			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25345

Purchase Order Date 8/11/2014

PO Print Date 9/15/2014

Page Number 1 of 2

Order From :

VC-GLO001

ARCHER PRECISION INC.
2228 GLADWIN CRESENT
OTTAWA, ON K1B 4S6
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 899 2405

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	d4476-042p	Small Rib Assembly,RH	8/11/2014 Yes 9/4/2014	FN	2.00 Each	\$164.67	\$329.34
Manufacture as per Drawing D4476 rev.B Batch 123279							
Line Total:							\$329.34
2	D4473-042P	Smal Rib Assy, RH	8/11/2014 Yes 9/4/2014	FN	2.00 Each	\$164.67	\$329.34
Manufacture as per Drawing D4473 rev.B Batch#123280							
Line Total:							\$329.34
3	D4494-042P	Upper Block Assy,RH	8/11/2014 Yes 9/4/2014	FN	2.00 Each	\$222.33	\$444.66
Manufacture as per Drawing B4494 rev.D Batch# 123278							

PO Instructions: Fedex Acc#151793240

Note:

9/15/2014



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25345

Purchase Order Date 8/11/2014

PO Print Date 9/15/2014

Page Number 2 of 2

Order From :

VC-GLO001

Ship To : DART AEROSPACE LTD

ARCHER PRECISION INC.
2228 GLADWIN CRESENT
OTTAWA, ON K1B 4S6
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613 899 2405

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

Buyer

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

EXW - (Ex Works)

Line Total: \$444.66

4 71401-45

8/11/2014

0.00

\$0.00

\$0.00

No

9/4/2014

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER,
(DOCUMENTATION SENT TO DART AEROSPACE)

A016 PERSONNEL QUALIFICATION

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A040 NOTIFICATION OF QUALITY ESCAPE

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENTS

Line Total: \$0.00

5 D4494-1P ✓

Upper Block Lower Door,
LH

8/11/2014

2.00

\$222.33

\$444.66

Yes

9/15/2014

Each

AS PER DWG D4494 REV. D
B124554

Line Total: \$444.66

PO Total: \$1,548.00

PO Instructions: Fedex Acc#151793240

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 4

Change Date: 9/15/2014



2228 Gladwin Crescent
Ottawa, Ontario
K1B 4S6

Phone # 613-899-2405

Packing Slip

Date	Invoice #
11/28/2014	1272

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
25346	11/28/2014	delivered	Archer	

Qty	Item Code	Description
2 ✓	Sales	D4494-041P ✓ HST (ON) on sales CZ/4/12/01



2228 Gladwin Cres.
Ottawa, Ont.
K1B 4S6

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

28 Nov 2014

Po Number	Part Number	Quantities
25346	D4494-041P	2

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 25346 issued by Dart Aerospace Inc.

Greg Kumbula
Quality Inspector
Archer Precision Inc.
2228 Gladwin Cress.
Ottawa, Ontario

Inspection Report

Customer Name		DWG#		Rev	Part Name		Date	Job #
Page 1 of 3		Inspection Interval		Special Notes				
Item #	DWG. Dim	Tolerance	Operator	QA First Off		QA Final		
			First Off	A	R	A	R	
1	6.45		6.448					
2	3.32		3.318					
3	97°		✓					
4	2.72		2.718					
5	.34		.348					
6	.46		.463					
7	.632		.635					
8	.632		.635					
9	.098		.094					
10	6.11		6.106					
11	1.00		1.001					
12	4.313		4.314					
13	.81		.811					
14	.31		.313					
15	1.19		1.189					
16	.81		.812					
17	2.03		2.032					
18	.20		.202					
19	.31		.312					
20	.500		.501					
21	.56		.562					

Inspection Report

[illegible]

[illegible]

